

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021431**Date Inspected:** 17-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 14-

This QA Inspector observed the following work in progress: Shielded Metal Arc Welding (SMAW) of OBG Segment 13AE FL2-1 to FL2-2 weld, SEG3007G-004. ZPMC welder was identified as 068097. ZPMC QC was identified as Wang Xu. ZPMC QC Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-P-2211-B-U2-FCM-1.

Flux Cored Arc Welding (FCAW) of OBG Segment 13AE weld, SEG3007V-006. ZPMC welder was identified as 068501. ZPMC QC was identified as Wang Xu. ZPMC CWI was identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2233-ESAB.

Flux Cored Arc Welding (FCAW) of OBG Segment 13AE floor beam to longitudinal diaphragm stiffener weld, SEG30007T-231. ZPMC welder was identified as 066733. ZPMC QC was identified as Wang Xue. ZPMC CWI was identified as Geng Wei. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2231-ESAB.

Shielded Metal Arc Welding (SMAW) of OBG Segment 13CE side panel stiffener weld, SEG3011A-132 and 133. ZPMC welder was identified as 067765. ZPMC CWI was identified as Zhong Yang Gang. ZPMC CWI was

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identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2232-ESAB.

Caltrans QA performed and recored root gap measurements for Hinge Plate stiffeners to longitudinal diaphragms on OBG Segment 14E.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation between QA and QC occurred this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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